

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007607**Date Inspected:** 19-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 2:

1AAE

This Caltrans QA inspector monitored activities related to internal stiffener replacement for Partial Joint Penetration (PJP) welds exceeding Welding Procedure Specification root gap tolerance on OBG segments 1AAW and 1AAE.

The following stiffener welds that were tested and accepted by ZPMC MT technicians were verified and accepted by QA.

A00- SEG2E-334, 124

SEG2F-026, 124

SRG2D-004, 088

A04- SEG2E-378, 338

SEG2D-103

A09- SEG2E-301, 343

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SEG2D-116

A32- Caltrans QA performed MT verification of ZPMC tested and accepted base metal excavation area.

A38- During random visual inspection of 1AAE fill plates QA observed a 65 mm linear indication on the fill plate fillet weld (side plate side). An incident report was issued for the above mentioned defect. Please see attached photos below.

This QA Inspector observed the following work in progress: FCAW welding of stiffener weld joints SEG2F-004 and SEG2E-046 located at location A41. ZPMC welder was identified as 048433. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2333-TC-P4-F.

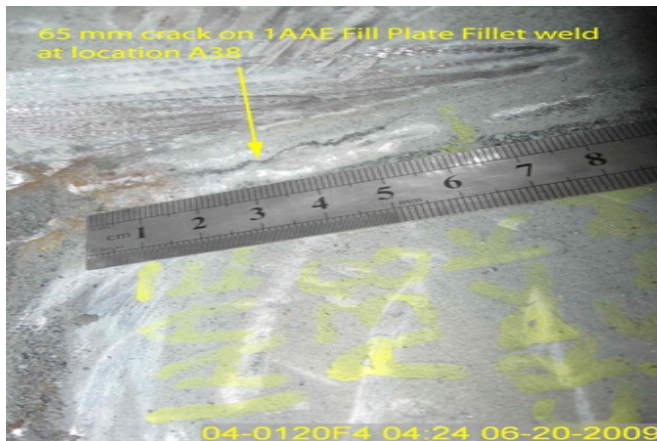
Joint Fit-up of stiffeners verified by ZPMC ABF and CT:

1. Weld joints SEG2F-044, 025 located on A41

1AAW

Caltrans QA observed ZPMC QC performing UT of CJP welds SEG1E-1000 and 1001. Welds were not accepted by ZPMC. ZPMC stated the UT for was information purposes only as the Final Magnetic Particle and Ultrasonic Testing had not been performed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
